

Date: Friday, 11/18/2005 3:16:15 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE, OUTBOARD, RH, 206
Job Number	: 24848		
Estimate Number	: 10523		
P.O. Number	: N/A	Part Number	: D26652
This Issue	: 11/18/2005	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2665 REV. B
First Issue	: N/A	Project Number	: N/A
Previous Run	: 23921	Drawing Revision	: B
	Type : MACHINED PARTS	Material	: N/A
Written By	: See comment below	Due Date	: 12/20/2005
Checked & Approved By	: See comment below	Qty:	12
Comment	: Est: C 00.11.01 Removed P/O for Powder Coat - in house process EC	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101003	7075-T7351 2X6.25X7.875
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)

7075-T7351 2X6.25X7.875

Cut Size 2.0" x 6.25" x 7.88"

Grain Along Long 7.88 Length

En 06/01/12

12

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1

1- Program batch number

En 06/01/12

2- Machine Step # 1 of Folio and visually inspect as per attached Dimension Sheet

3- Machine Step # 2 of Folio and visually inspect as per attached Dimension Sheet

4- Machine Step # 3 of Folio and visually inspect as per attached Dimension Sheet

5- Deburr

En 06/01/13

12

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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**Comment:** CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

En 06/01/13

12

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

En 06/01/13

12

5.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

En 06/01/13

12

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 11/18/2005 3:16:15 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE, OUTBOARD, RH, 206

Job Number: 24848

Part Number: D26652

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
Acid etch and Alodine as per QSI 005 4.1

SAD 08/01/14 12

7.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 06 01 16 12

8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT

P 01/1/14 (12)

9.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: 363

P 01/1/16 (12)

10.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL
Inspection Level 21

SAC 06/01/18 (12) DP 06/01/18 (12)

Job Completion



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 12 Date: 06/01/18
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 24848
Description: 206 Saddle, Outboard, Right side	Part Number: D2665-2
Inspection Dwg: D2665 Rev. B	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		0.120	0.120	0.120	0.121		
B	0.100	0.140		0.118	0.118	0.120	0.121		
C	0.100	0.140		0.118	0.119	0.119	0.119		
D	0.210	0.230		0.219	0.220	0.218	0.216		
E	1.245	1.255		1.248	1.247	1.247	1.247		
F	1.245	1.255		1.248	1.247	1.247	1.247		
G	5.990	6.010		6.002	6.002	6.004	6.002		
H	0.510	0.515		0.512	0.512	0.512	0.512		
I	1.674	1.684		1.678	1.679	1.678	1.678		
J	2.495	2.505		2.498	2.50	2.499	2.500		
K	0.257	0.262	DT8683	0.259	0.259	0.257	0.259		
L	0.312	0.317	DT8686	0.312	0.312	0.312	0.312		
M	0.235	0.240		0.237	0.238	0.237	0.237		
N	0.100	0.140		0.119	0.117	0.120	0.117		
O	0.540	0.560		0.544	0.546	0.546	0.545		
P	0.490	0.510		0.499	0.497	0.494	0.501		
Q	3.609	3.619		3.612	3.612	3.612	3.611		
R	2.470	2.510		2.494	2.500	2.497	2.498		
S	0.240	0.270		0.248	0.248	0.247	0.247		
T	0.100	0.180		0.140	0.140	0.140	0.140		
U	0.313	0.318	DT8686	0.318	0.318	0.318	0.318		
V	1.125	1.145		1.136	1.136	1.137	1.135		
W	1.565	1.585		1.575	1.574	1.575	1.573		
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	EP
Date:	06/01/12

Audited by:	ML
Date:	06/01/12

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	

DART AEROSPACE LTD	Work Order: 24848
Description: 206 Saddle, Outboard, Right side	Part Number: D2665-2
Inspection Dwg: D2665 Rev. B	Page 1 of 1

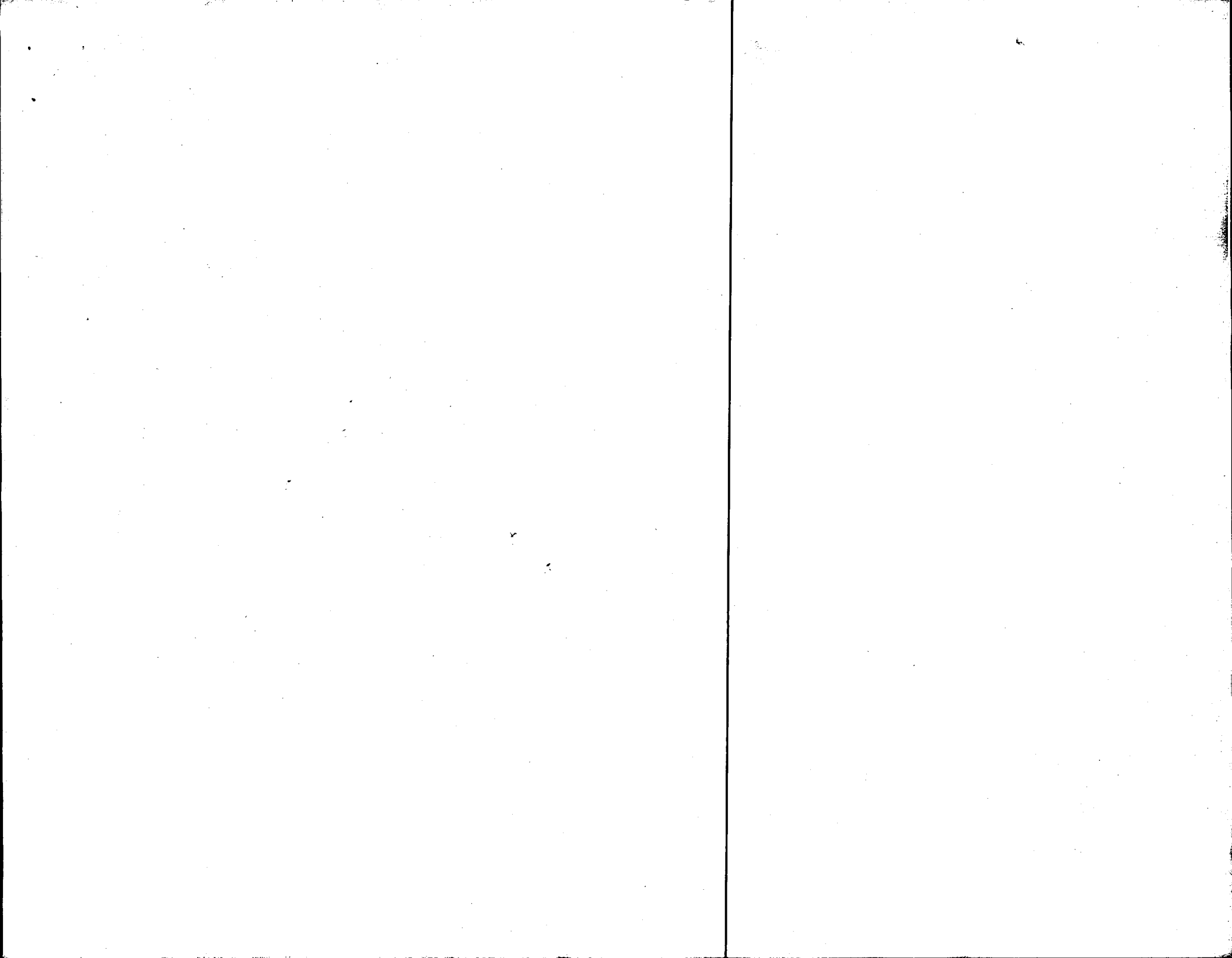
Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		0.119	0.119	0.121	0.119		
B	0.100	0.140		0.120	0.119	0.121	0.118		
C	0.100	0.140		0.119	0.124	0.121	0.115		
D	0.210	0.230		0.216	0.217	0.217	0.218		
E	1.245	1.255		1.247	1.246	1.246	1.248		
F	1.245	1.255		1.247	1.246	1.246	1.248		
G	5.990	6.010		6.002	6.003	6.002	6.002		
H	0.510	0.515		0.512	0.512	0.512	0.512		
I	1.674	1.684		1.679	1.678	1.678	1.678		
J	2.495	2.505		2.500	2.499	2.500	2.499		
K	0.257	0.262	DT8683	0.259	0.259	0.259	0.259		
L	0.312	0.317	DT8686	0.312	0.312	0.312	0.312		
M	0.235	0.240		0.238	0.238	0.239	0.237		
N	0.100	0.140		0.118	0.120	0.119	0.119		
O	0.540	0.560		0.545	0.543	0.545	0.544		
P	0.490	0.510		0.494	0.497	0.499	0.499		
Q	3.609	3.619		3.610	3.612	3.611	3.611		
R	2.470	2.510		2.492	2.497	2.499	2.494		
S	0.240	0.270		0.248	0.250	0.250	0.248		
T	0.100	0.180		0.140	0.140	0.140	0.140		
U	0.313	0.318	DT8686	0.318	0.318	0.318	0.318		
V	1.125	1.145		1.135	1.135	1.136	1.137		
W	1.565	1.585		1.574	1.574	1.576	1.577		
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	ED
Date:	06/01/13

Audited by:	Am
Date:	06/01/13

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	



DART AEROSPACE LTD	Work Order:	<i>24848</i>
Description: 206 Saddle, Outboard, Right side	Part Number:	D2665-2
Inspection Dwg: D2665 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		0.117	0.117	0.119	0.121		
B	0.100	0.140		0.120	0.120	0.124	0.119		
C	0.100	0.140		0.120	0.120	0.123	0.119		
D	0.210	0.230		0.217	0.216	0.217	0.218		
E	1.245	1.255		1.247	1.247	1.247	1.248		
F	1.245	1.255		1.247	1.247	1.247	1.248		
G	5.990	6.010		6.001	6.001	6.002	6.002		
H	0.510	0.515		0.512	0.512	0.512	0.512		
I	1.674	1.684		1.678	1.678	1.678	1.677		
J	2.495	2.505		2.499	2.500	2.500	2.499		
K	0.257	0.262	DT8683	0.259	0.257	0.259	0.257		
L	0.312	0.317	DT8686	0.312	0.312	0.312	0.312		
M	0.235	0.240		0.237	0.238	0.237	0.237		
N	0.100	0.140		0.120	0.118	0.119	0.116		
O	0.540	0.560		0.544	0.546	0.545	0.545		
P	0.490	0.510		0.495	0.500	0.498	0.501		
Q	3.609	3.619		3.612	3.612	3.610	3.612		
R	2.470	2.510		2.500	2.499	2.499	2.495		
S	0.240	0.270		0.249	0.249	0.249	0.249		
T	0.100	0.180		0.140	0.140	0.140	0.140		
U	0.313	0.318	DT8686	0.318	0.318	0.318	0.318		
V	1.125	1.145		1.135	1.136	1.136	1.135		
W	1.565	1.585		1.575	1.575	1.575	1.574		
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	<i>Ed</i>
Date:	<i>06/01/13</i>

Audited by:	<i>gml</i>
Date:	<i>06/01/13</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 17, 2005
03:30 pm

Work Order No	: 0024848	Department Code:	
Project Name	: D2665-2	Burden Flags	: NNNNNNNN
Project For	: WK551	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: D2665-2	Invoice Number	:
Description	: Saddle, RH, Fwd,Aft, Out	Invoice Amount	: 0.00
Manufactured	: Yes		
Amount Req'd	: 12	Order Entry No	:
Amount Done	: 0	OE Value	: 0.00
Start Date	: 11-17-05		
Est Finish Date	: 12-21-05	Est Margin	: 0.000%
Act Finish Date	:	Actual Margin	: 0.000%
Drawings Req'd	: No		
Ok for Approval	:		
Approval Rec'd	:	\$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	: 0.00	0.00	0.00	0.00	0.00
Engineering Hours	: 0.00	0.00	0.00		
Engineering Cost	: 0.00	0.00	0.00	0.00	0.00
Production Hours	: 0.00	0.00	0.00		
Production Cost	: 0.00	0.00	0.00	0.00	0.00
Packaging Hours	: 0.00	0.00	0.00		
Packaging Cost	: 0.00	0.00	0.00	0.00	0.00
OverHead Hours	: 0.00	0.00	0.00		
OverHead Cost	: 0.00	0.00	0.00	0.00	0.00
CNC Hours	: 0.00	0.00	0.00		
CNC	: 0.00	0.00	0.00	0.00	0.00
Misc. Hours	: 0.00	0.00	0.00		
Misc.	: 0.00	0.00	0.00	0.00	0.00
Burden	: 0.00	0.00	0.00		
Total Cost	: 0.00	0.00	0.00		
Margin	: 0.000	0.000			
Selling Cost	: 0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/(Loss)	: 0.00	0.00